

Work Order ID 69282

Friday, May 06, 2011 11:33:01 AM

Page 1

Item ID: D3791-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 5/6/2011 Start Qty: 10.00

Required Date: 5/9/2011 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 5-05-6

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3791

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3791

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

BS11-5-8

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

BS11-5-8

(17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Friday, May 06, 2011 11:33:01 AM

Page 2

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Run Start

Stop

**Insp.
Stamp**

0.00

0.00 δ wcos/09

Memo

0.00

412

0.00

NC BRAKE

Memo

0.00

1-Deburr if necessary

2-Form on Brake as per Dwg D3791 using Jigs

SB 11/5/10

0.00

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

8/11/51

412

W/O:		WORK ORDER CHANGES					
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Page 3

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Start Date: 5/6/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Large Fab	0.00							
Large Fab	Memo	0.00				212		11-08-11	JRL
Large Fab	1-Weld hardcoat as per dwg D3791 QSI004								
	Hardcoat 2059b Batch: M118453								
160 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

Suloom

S u / o s l n

(42)

11-08-11 JRL
11-08-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 69282

Friday, May 06, 2011 11:33:01 AM



Page 4

Item ID: D3791-1

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Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 5/6/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>11117338</i> Memo START TIME: <i>1:30pm</i> OVEN TEMPERATURE: <i>320°F</i> FINISH TIME: <i>2:00pm</i>	0.00 0.00				<i>12</i>	<i>0</i>	<i>11/08/11</i>	
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00						<i>12</i>	<i>11/08/11</i>
200 Packaging Packaging	Identify as per dwg & Stock Location: <i>FP-1A</i> Memo	0.00 0.00				<i>12</i>	<i>0</i>	<i>11/08/11</i>	

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Page 5

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Item Name: Wearplate

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Required Date: 5/9/2011 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/12

R11-08-11
(12)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, May 06, 2011 11:33:07 AM

Work Order ID: 69282



Parent Item: D3791-1



Parent Item Name: Wearplate



Start Date: 5/6/2011

Required Date: 5/9/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	98.5000	0.2917	3.070526	3.5		
											1811-59		

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

98.5

117275

98.5

117275

(12)

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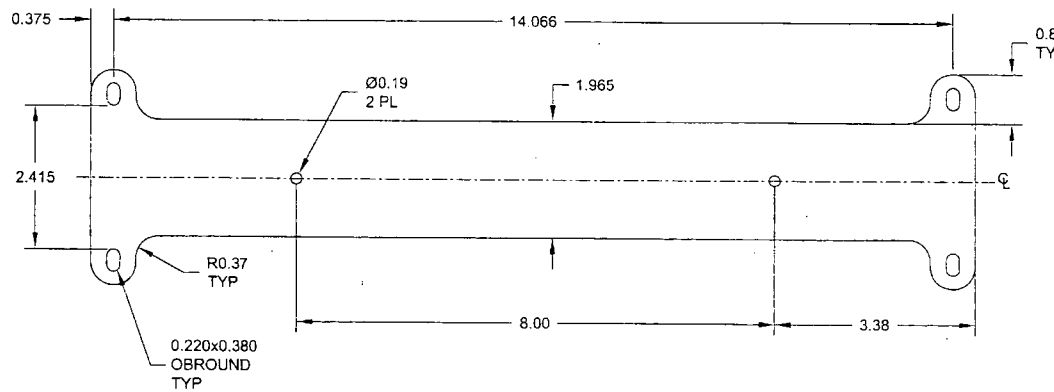
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

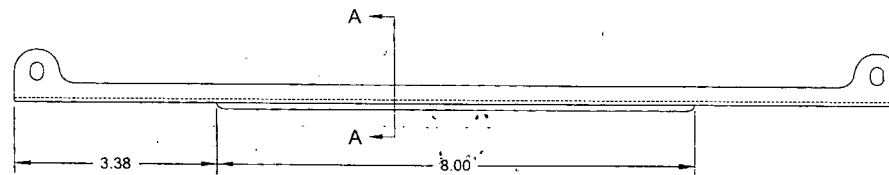
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. *09282*

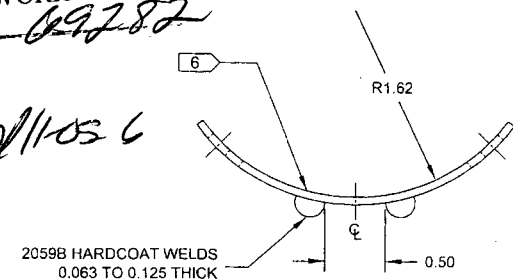
PH/1056



D3791-1F FLAT PATTERN



D3791-1 WEARPLATE
(MAKE FROM D3791-1F)



SECTION A-A
SCALE 2X

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

RELEASED
08-05-21/18

A		NEW ISSUE		PH	08.05.13
REV.	DESCRIPTION			BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA			
DRAWN	PH				
CHECKED					
MFG. APPR.	DS				
APPROVED	PH				
DE APPR.	PH	DRAWING NO.	REV. A		
		D3791	SHEET 1 OF 1		
		TITLE	SCALE		
		WEARPLATE	NTS		
DATE	08.05.13	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC			

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